

Date: Wednesday, 30/07/2008 11:12:20 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT T-HANDLE ASSY
Job Number	: 40816		
Estimate Number	: 13529		
P.O. Number	:	Part Number	: PB674300163
This Issue	: 30/07/2008 S.O. No. :	Drawing Number	: B6743001 P.15
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 06/08/2008 Qty: 3 Um: Each
Checked & Approved By	: <u>MF 08-08-30</u>		
Comment	: Est Rev:A 08-07-29 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001131	Tube End Cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Tube End Cap

batch: 340020

MF 08.01.08 3

2.0	PB6743001129	Tube Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Tube Handle

batch: M10537

MF 08.07.08 3

3.0	PB6743001127	Handle Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Handle Arm

batch: M10537

MF 08.01.08 3

4.0	PB6743001157	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Tube

batch: M10537

MF 08.01.08 3

5.0	CR321342	Cherry Rivet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Cherry Rivet

batch: 102569

MF 08.08.12 3

Date: Wednesday, 30/07/2008 11:12:20 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT T-HANDLE ASSY

Job Number: 40816

Part Number: PB674300163

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps, to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8- install rivet as per dwg

Handwritten: 08.07.08 3

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 08-08-12 (3)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/08/12 (3)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Handwritten: M102316

Handwritten: (3X)

****mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat****
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Handwritten: 3:30
320 °F
4:00

Handwritten: M-1 08/08/12

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08-08-13

Handwritten: (3X)

11.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

SPRING SLOTTED PIN

batch:

Handwritten: 7830

Handwritten: 08.08.26

3

Date: Wednesday, 30/07/2008 11:12:21 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT T-HANDLE ASSY

Job Number: 40816

Part Number: PB674300163

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PB6743001133

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

batch: 323994

08-08-26 3

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble by drilling thru both -157 and -133 as per dwg

2- install spring slotted pin as per dwg

08-08-26 3

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/26 (x3)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

39952

16.0

QC21

FINAL INSPECTION/W/O RELEASE



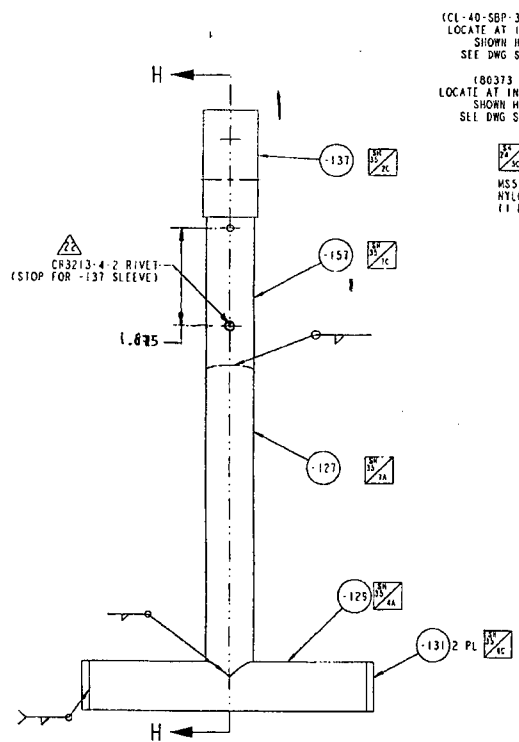
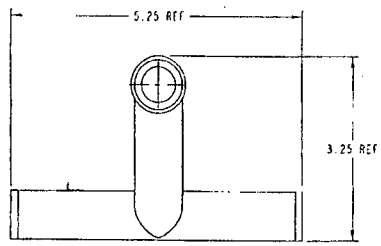
Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

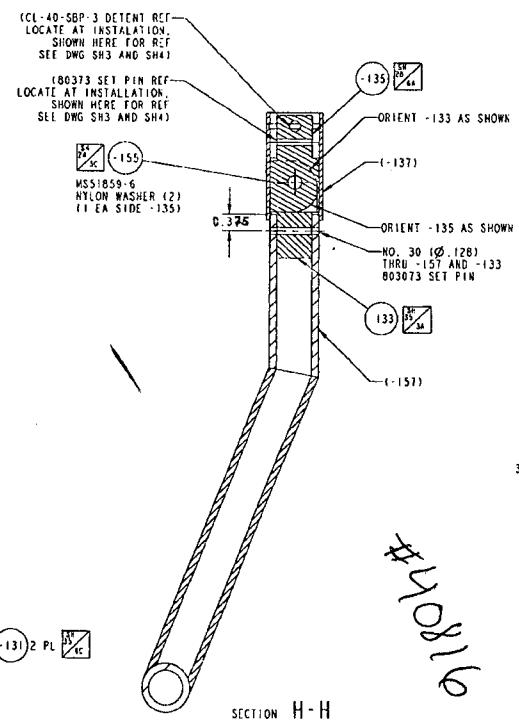
Job Completion



08/08/26

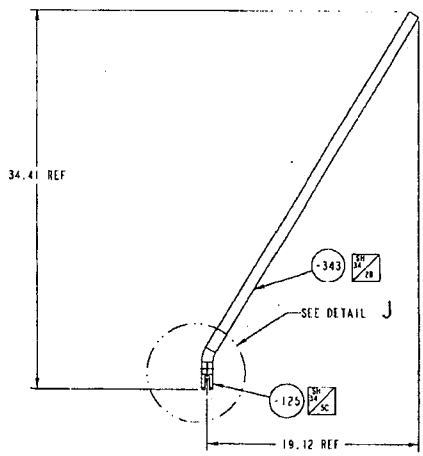
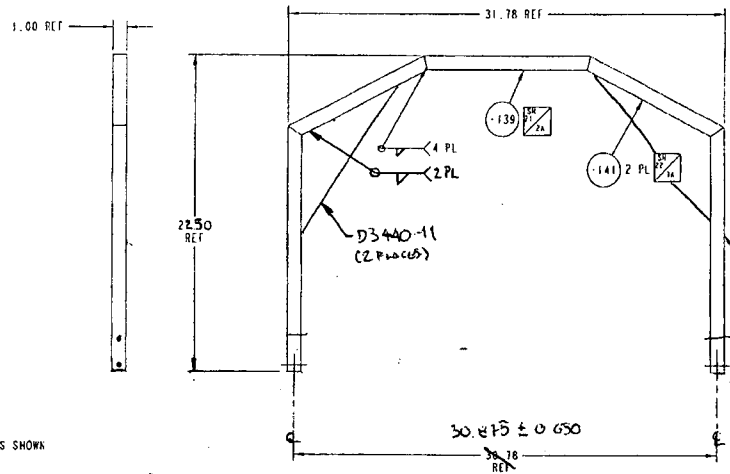


① -63 SHORT T-HANDLE ASSEMBLY
SCALE 1.000



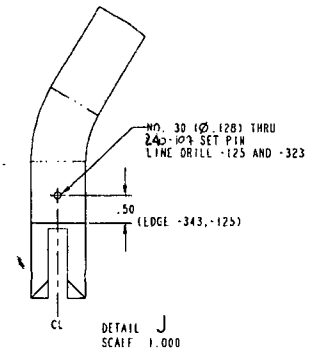
SECTION H-H

#40816



① -37 TUBE ARM ASSEMBLY
SCALE 0.700

~~-63 BASE ASSEMBLY~~ (COMMERCIAL VERSION)
SCALE 0.250
~~-47 BASE ASSEMBLY~~ (CANADIAN VERSION)



DETAIL J
SCALE 1.000

PREMIER AVIATION, INC.			
2001 Aviation Parkway, Grand Prairie, Texas 75050			
11/18/88	CON. REV. NO.	DOC. NO.	REV.
DISUV8		B67-43001	B1
SCALE	UNIT	SHEET	15 OF 45

ORIGINAL